

Date: Monday, 09/03/2009 1:42:23 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 46333A	
Estimate Number : 10375	
P.O. Number :	Part Number : D30651
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 45395A	Material :
Written By :	Due Date : 27/03/2009 Qty: 40 Um: Each
Checked & Approved By : <u>09.03.09</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Est:D 06.04.25 Water jet EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S040

2024-T3 .040 sheet



Comment: Qty.: 0.1300 sf(s)/Unit Total: 5.1996 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: _____

B 9-3-31

107572 x 164 2.5
 109461 x 19 = 2.5

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3065

Dwg Rev: BProg Rev: B

B 9-3-31

57

2-Deburr as required

B 9-3-31

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 9-3-31

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8 02/04/01 counter
 57

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE

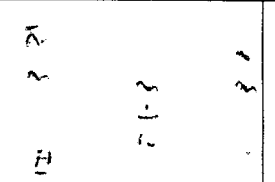
Deburr if necessary.

1/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		<div style="text-align: center;">  </div>						

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:23 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 46333A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

EP 09/04/01 (57)

SB 09/04/06 (57)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/07 (57)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP/DR.

09/04/07

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FD 09/04/07

(57)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *G-A*

EP 09/04/07 (57)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



MF 09-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46333A
Description: Step Spacer		Part Number: D3065-1
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.249	✓			
2.093	+/-0.010	2.093	✓			
3.936	+/-0.010	3.937	✓			
4.186	+/-0.010	4.186	✓			
0.587	+/-0.010	.588	✓			
Ø0.128	+0.005/-0.001	.129	✓			
R0.125	+/-0.010	.125	✓			
3.465	+/-0.010	3.467	✓			
Ø1.250	+0.012/-0.001	1.252	✓			
0.368	+/-0.010	.369	✓			
0.871 (Pitch)	+/-0.005	.873	✓			
0.040	+/-0.010	.041	✓			

Measured by: B	Audited by: S	Prototype Approval: 1/9
Date: 9-3-31	Date: 09/01/09	Date: 1/9

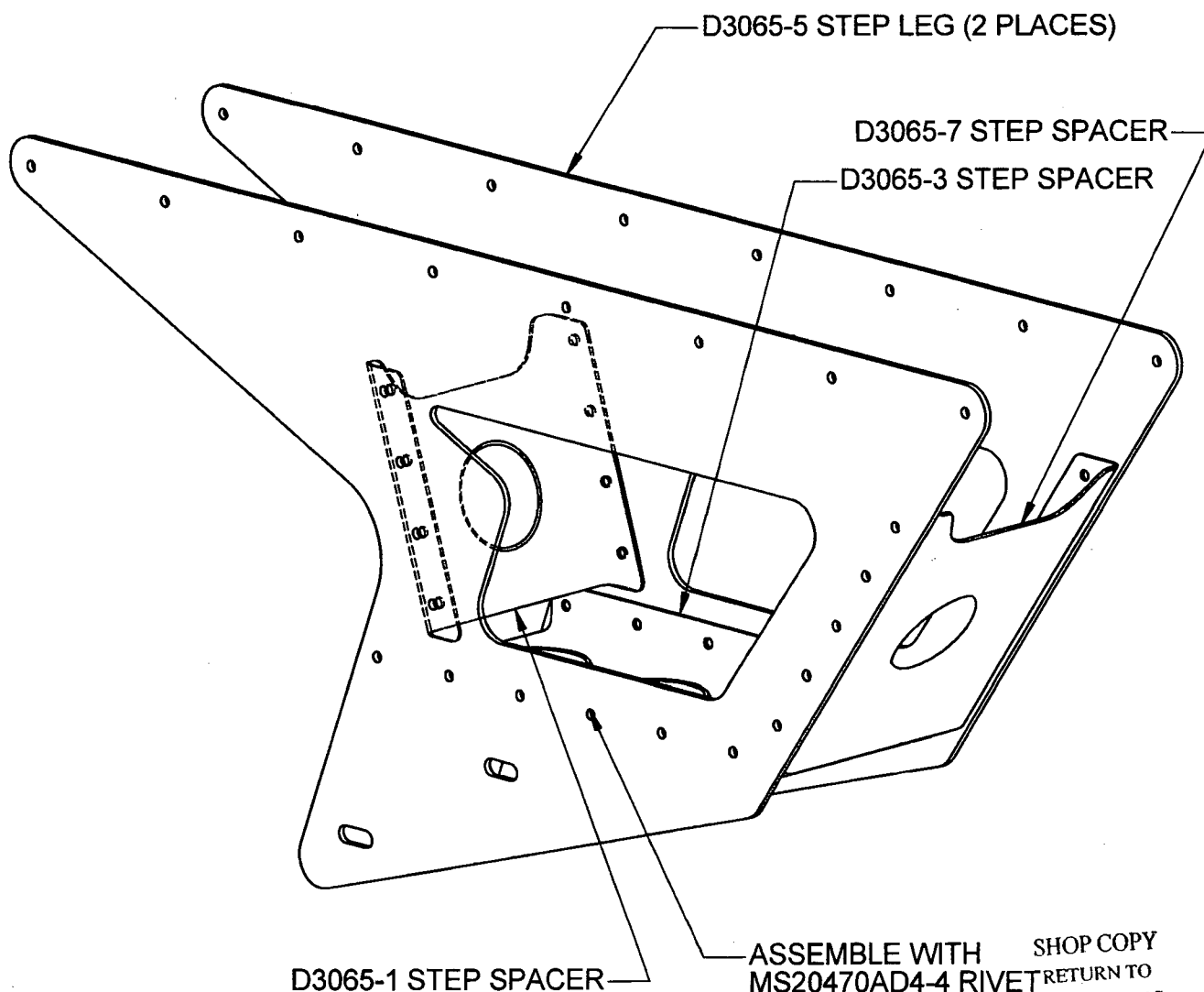
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

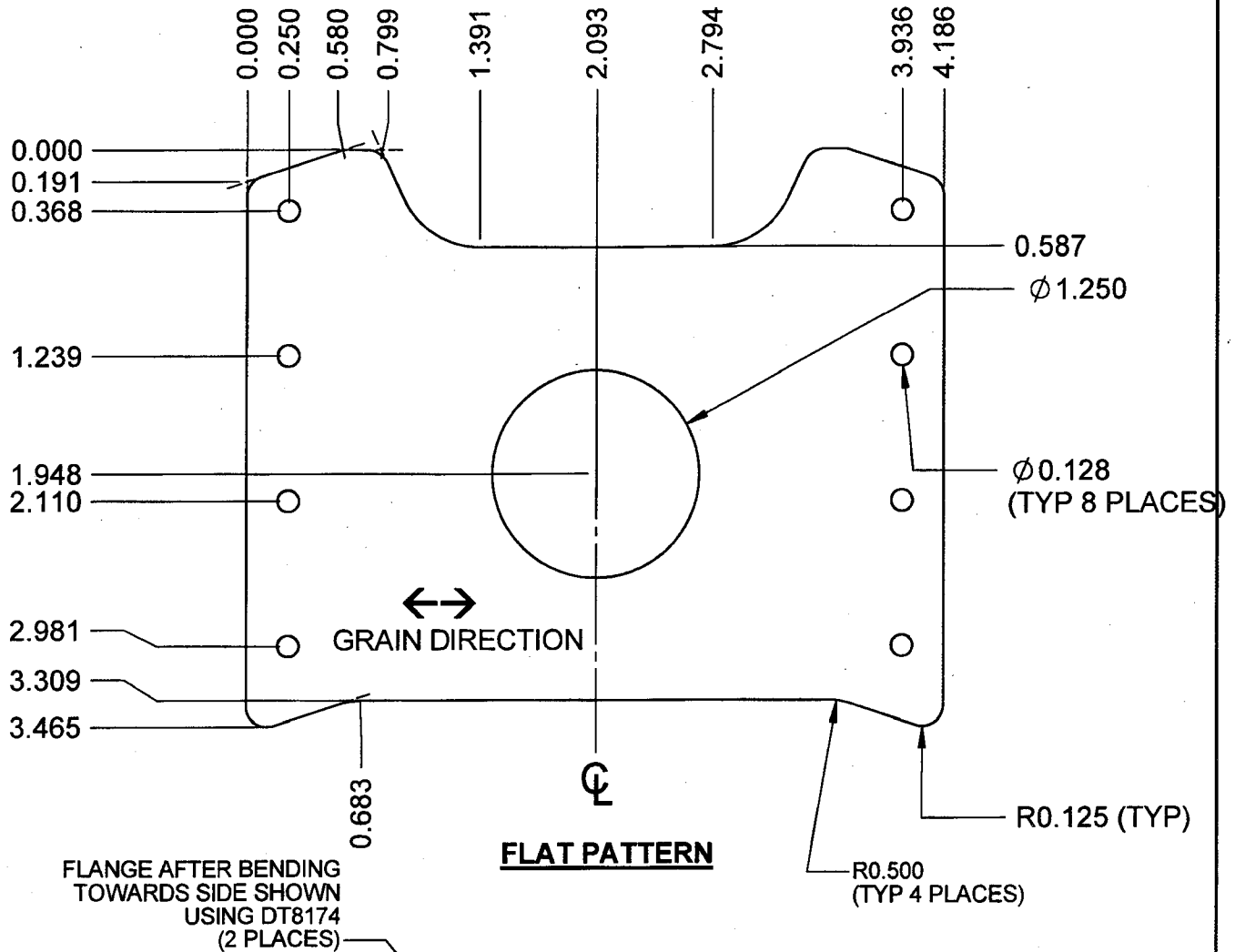
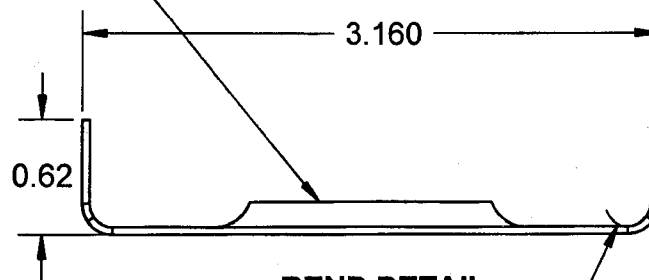
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***de de-ro***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

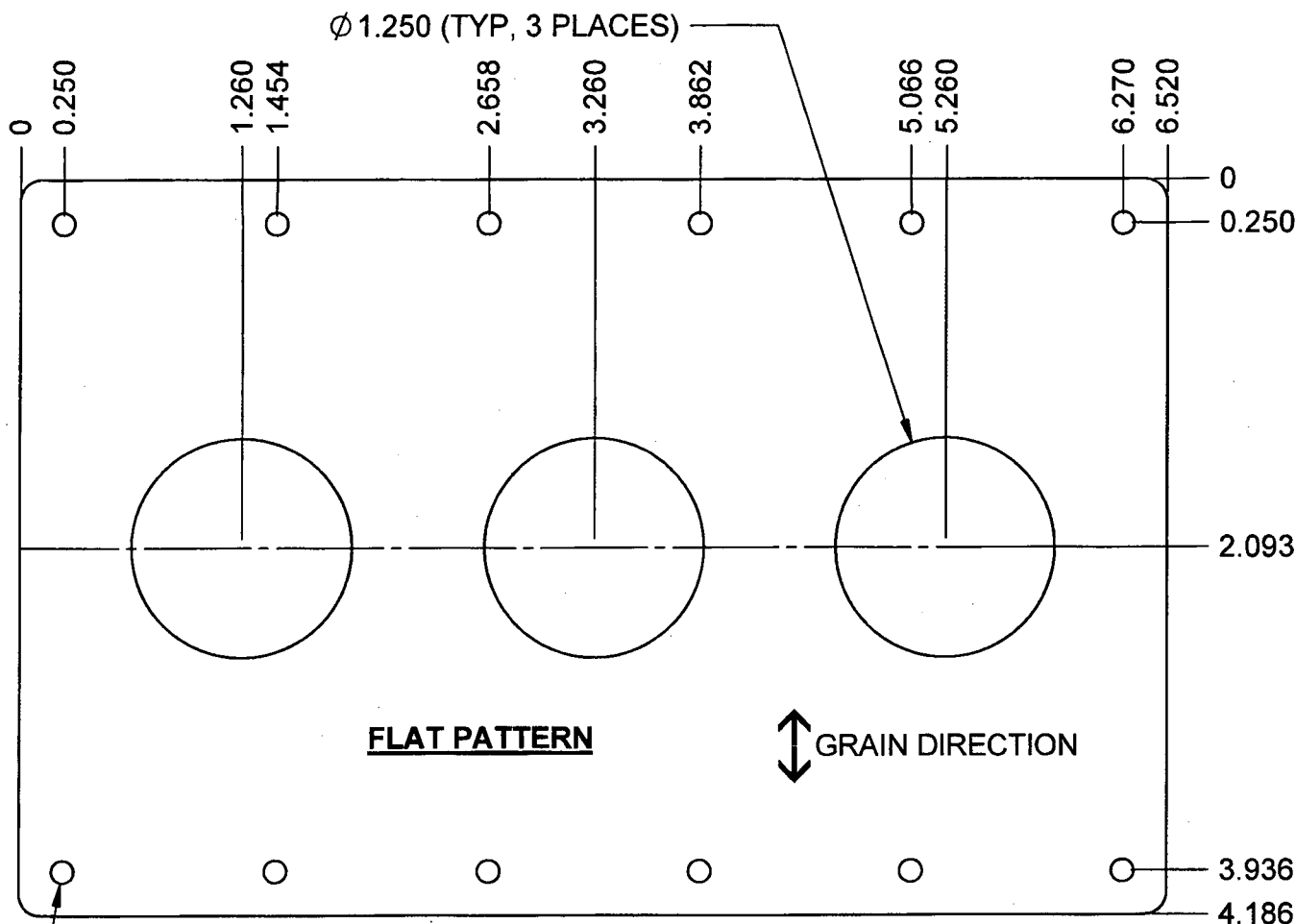
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

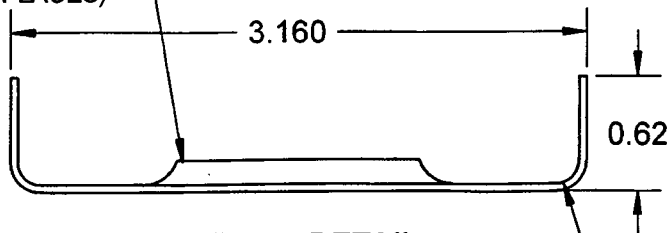


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

Chk ch 20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

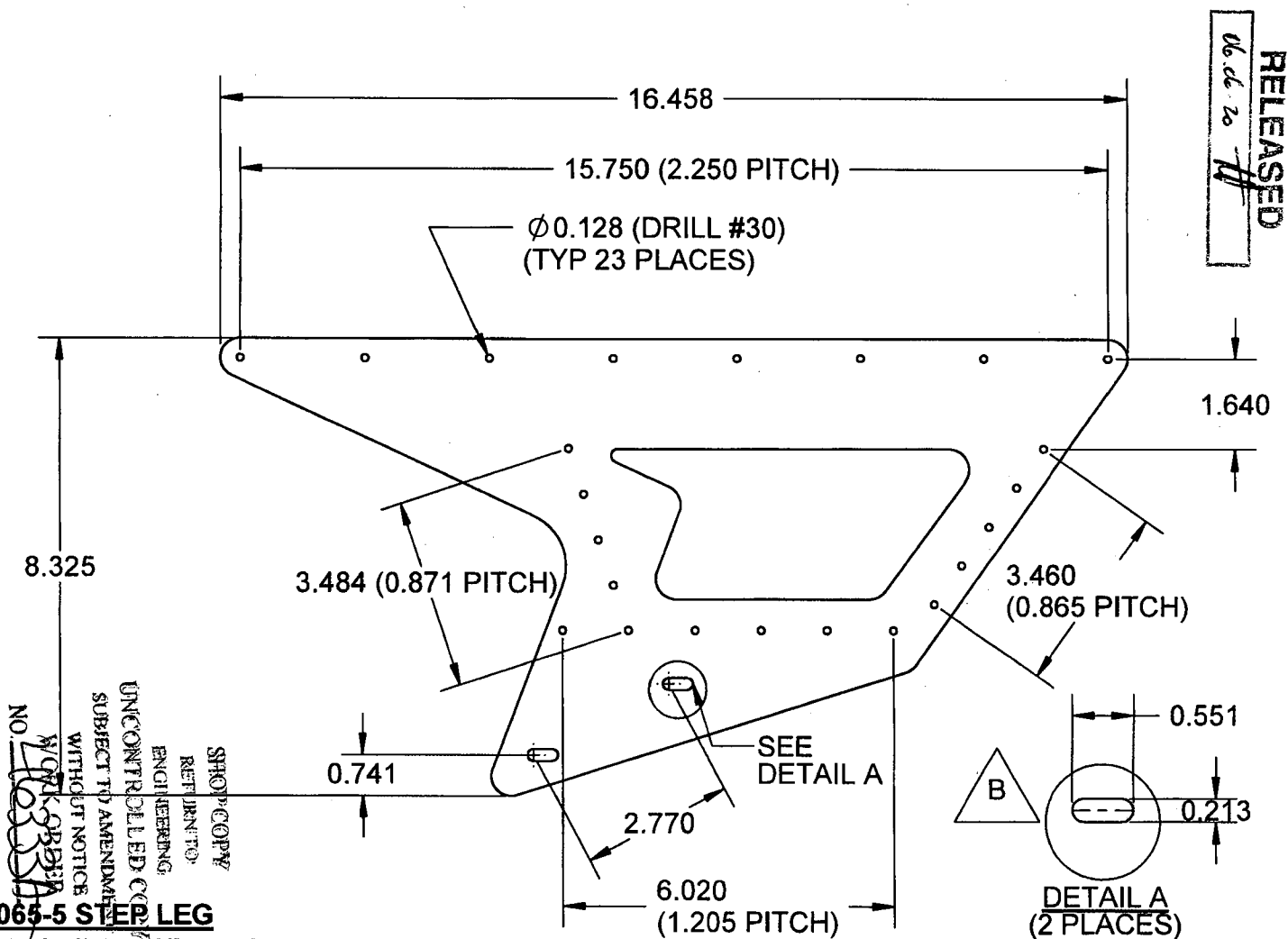
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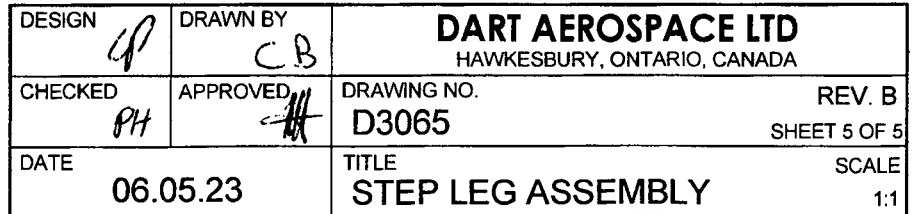
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CHECKED PH	APPROVED CB	DRAWING NO. D3065	REV. B
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SHEET 4 OF 5	
		SCALE 1:3	



- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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FLAT PATTERN

RELEASED

06 06 20

SIDE ELEVATION

3.160

0.62

BEND DETAIL

R0.125 (TYPE)
RETURN TO

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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